

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006388**Date Inspected:** 26-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Ming and Chen Ying Xin			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower and OBG		

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as North Tower Lift 3 Skin D. The weld designations reviewed are as follows:

Bay 10

1. NSD1-FBAS3-3B/C-5A/B and 6A/B
2. NSD1-FBAS3-3A/C-28A/B and 29A/B

This QA Inspector observed the following work in progress:

SAW welding of weld joint 2A located on PCMK ESD1-A167B/H.

Welder is identified as Mr. Xu Xiushui (040489). ZPMC QC is identified as Mr. Liu Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

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FCAW welding of weld joint 139 located on PCMK NSD1-A166H/J.

Welder is identified as Mr. Yu Jun (201825). ZPMC QC is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint 9 and 8 located on PCMK NSD1-A166F/J.

Welder is identified as Mr. Xu Xiuping (057244). ZPMC QC is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-4133.

FCAW welding of weld joint 143 and 145 located on PCMK NSD1-A112E/H.

Welder is identified as Mr. Bai Wen Ming (040434). ZPMC QC is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

Bay 11

FCAW welding of weld joint 9 located on PCMK ESD1-SA107B/J.

Welder is identified as Mr. Xu Hua (049220). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-4132.

SMAW welding of weld joint 6A located on PCMK WD1-A467-43M-1.

Welder is identified as Mr. Xie Zhong Cheng (041271). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1

Bay 13

This QA Inspector observed the following work in progress:

SAW welding of weld joint 001 located on PCMK SEG047B.

Welder is identified as Mr. Zhang Min (215993). ZPMC QC is identified as Mr. C.M Chen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Bay 9

This QA Inspector observed ZPMC welder Han Hongwen (200149) welding (repair) on Deck Panel DP394-001(9CE) in OBG Assembly Shop (Bay 9). QC Inspector was not present at the time of work. QA Inspector issued an incident report on this date for the welding observed.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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